APPLICATION GUIDE

MirraChrome with Candy

HOW TO APPLY MIRRACHROME WITH CANDY COLOR

Surface Preparation:

1. Always apply paints in a well-ventilated area, and wear a NIOSH approved respirator to avoid breathing any fumes.
2. Make sure you have good conditions for spraying. The best temperature for spraying this paint, is 75-80 degrees F, and VERY low humidity.
3. Prepare and prime your part first. Epoxy primers are best for bare metal, and primer surfacers are best for plastics, fiberglass, or wood. Some plastics may require an adhesion promoter but most plastics, like ABS plastic, are fine without adhesion promoters. Our tech support department can assist with what primer is best, if you are uncertain.
4. Before applying your primer, remove all dirt, grease, oil, salt, and chemical contaminants, by washing the surface with a commercial detergent, or other suitable cleaning method.
5. Rinse with fresh water and allow to completely dry.
6. Remove any existing loose paint, or rust, etc, with a wire brush or sand paper.
7. Lightly sand glossy surfaces to create a surface profile for adhesion.
8. Apply your primer to the surface according to the manufacturers specifications for your particular primer.
9. Let your primer cure according to the manufacturers specifications for your particular primer, and then lightly scuff that to create a surface profile for adhesion.

Mirrachrome Application:

Mirrachrome is a VERY technique driven application. It is sold as a kit, as it is very sensitive to clears. You should only use OUR clear coat with this material.

This application can take a fair amount of practice to become proficient with. Patience is the KEY.

Test panels are strongly urged, in order to develop the correct “FEEL” for spraying the chrome material. A very light dusting technique will be needed, and is critical to the application. Over applying the Mirrachrome will result in a dull finish, similar to silver paint.

Application:

If applying over an ALREADY PAINTED SURFACE, lightly scuff the existing paint to create a surface for adhesion.

1.) We are starting with the black base coat (ASB-13). This is reduced 1:1 with the medium reducer in your kit (AMR2712).

Apply 2 coats of the black base coat to your prepared piece, with about 10-15 minutes flash time between coats.
Apply the 2 coats using a steady back and forth motion, about 6-10 inches from your substarate, until even coverage is achieved.
Once coated, let the black base coat flash for another 10-15 minutes, and then you are ready to clear coat the black base coat.

2.) Mix your CLEAR, NOT TINTED, Speed Clear (SC1230) with the included hardener (H-222) at a ratio of 4:1.
Now apply your speed clear over the black base coat, using steady even passes, from about 8-12 inches away from the substrate. Apply 2 medium wet coats with about 10 -15 minutes flash between coats.

At this point, you can should have a VERY wet glossy reflective black surface. This is a very important starting place for the application. You should have as close to a black mirror as possible befor proceeding, as seen here…

Then make sure the clear coat on your black base coat cures for a full 7 days, or bake overnight at 140 degrees F, to insure it is TOTALLY CURED. That is also critical to the application. If the clear coat is not fully cured, this will also dull the finish.

After curing for the full 7 days, you can now wet sand, and buff your clear coat, until it is as smooth as possible. Glass-like is ideal. The more glass-like your surface, the better the reflectivity will be.

You are now ready to begin chroming your piece.

3.) Touch-up gun is recommended. Set the material volume on your gun very low. Completely close the material volume, and then open it back up about ¼ of a turn. Apply the Mirrachrome (MC-101) to your clear coated black base coat, in a VERY LIGHT DUSTING FASHION, from about 8-10 inches away from the substrate, and at about 35-

40 PSI air pressure, continuing to make passes over the surface, and VERY BRISK PASSES, until you achieve the effect.

Moving your hand too slowly when making your passes will result in a "Stacking" of the metal particles, and kill the shine when top coated.

Here is the same tank pictured above after applying the Mirrachrome.

If you are getting a flat metal, or flat aluminum look, then the product is almost certainly over applied.
It is very easy to apply too much of the material. This is not uncommon, and can take PRACTICE. Test panels are encouraged, in order to develop a good “feel” for this dusting application.
What you are spraying is a hyper-ground metal (near molecular scale!), and you MUST NOT let this material stack up in any way.

You are not going for a "Coat of Paint" like with a regular liquid pigment. It needs to be dusted on extremely lightly, and evenly. This will take SEVERAL PASSES. Keep your eye on the clear coated black as you are making your passes, and when you reach the point that it looks like the last TINY BIT of black has JUST winked out of sight, stop right there.

Let this dry for 24 hours, and then you can take the polishing cloth included in your kit, and slightly dampen that, and VERY GENTLY wipe down the piece. This will help remove any metal particles that are "stacked up" on the surface, but not really stuck to anything. The material is so finely ground (near molecular scale) that you can actually wind up with a fair amount of this material (depending on how heavily it was sprayed) on the surface, that is not stuck to the clear coat on the black. It is just sitting there like a "nano-dust". WHEN TOP COATED THESE LOOSE PARTICLES WILL FLOAT UP INTO THE TOP COAT, AND HURT THE REFLECTIVITY VERY BADLY.
Do not apply too much pressure when wiping the Mirrachrome down, or you may move the pigment that is STUCK to the clear coat, and that will spoil the finish.

You are now ready to top coat the Mirrachrome with your candy coloring.

1.) 4). Mix your TINTED Speed Clear (SC1230) with the included hardener (H-222) at a ratio of 4:1. Apply one medium wet coat of your TINTED Speed Clear over the Mirrachrome. Apply this in a VERY steady, even passes, and as perfectly as possible, as this is the coat that will lock down the Mirrachrome material, and have the most impact on final appearance.

Let this dry for 24 hours.

If additional coats are desired/required, then after waiting 24 hours for the first coat to cure, lightly scuff the clear, and shoot your additional coats over that, as you would any clear coat.

Please note: Since this tinted top coat remains translucent, the more coats of tinted clear you apply , the DARKER the final color will be.

We also recommend applying at least one additional coat of NON TINTED Speed Clear, as a FINAL top coat over the tinted clear. This will provide an additional UV barrier, and allow for polishing and buffing, without disturbing the color.

You have now completed your Mirrachrome paint job!

If after reading through this application guide, you find you are still having trouble, and require more assistance, please do not hesitate to contact our technical support staff. They are available Monday through Thursday, 8am – 4pm, and Fridays, 8am – 12pm. You can reach us toll free at 1-800-999-4120